

Date: Wednesday, 12/5/2007 10:36:52 AM
 User: Kim Johnston

Process Sheet

| | |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BACK FRAME ASSEMBLY |
| Job Number : 36146 | |
| Estimate Number : 11129 | |
| P.O. Number : | Part Number : D3017041 |
| This Issue : 12/5/2007 S.O. No. : | Drawing Number : D3017 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : A |
| Previous Run : 34895 | Material : |
| Written By : <u> </u> | Due Date : 1/10/2008 Qty: 1 Um: Each |
| Checked & Approved By : <u> </u> | |
| Comment : Est. A 01.09.19 New issue EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------------|--------------------------|
| 1.0 | M4130NT0750W049 | 4130 Tube .750 OD x.049W |
|-----|-----------------|--------------------------|



Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)

4130 Tube .750 OD x.049W

Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall

Batch: M100813

PD 08-01-16 ①

| | | |
|-----|------------|----------------------|
| 2.0 | M4130NS049 | 4130 Sheet .049 wall |
|-----|------------|----------------------|



Comment: Qty.: 0.1260 sf(s)/Unit Total : 0.1260 sf(s)

4130 Sheet .049 wall

Cut:- AISI 4130N sheet, 18 gauge (0.050 thick)

Batch: M11612

PD 08-01-16

| | | |
|-----|--------|-----|
| 3.0 | D30177 | Lug |
|-----|--------|-----|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Lug

Pick:

| | | | |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch |
| 3 | D3017-7 | Lug | <u>B22411</u> |

PD 08-01-16

| | | |
|-----|-------------|------------------------------|
| 4.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3017

2-Cut end caps as per Dwg D3017

3-Weld as per Dwg D3017 using Welding Jig Dt8598

A/R Steel Rod Batch: M100075

PD 08-01-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 10:36:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 36146

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill D3017-041 Using DT8621

5-Deburr

PD 08-01-16 (1)

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/01/29 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/29 (1)

7.0

POWDER COATING

POWDER COATING



M106442



(X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 08/02/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-05

(X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SP 08/02/06

(1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

Job Completion



2008/2/07 (1)

W

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



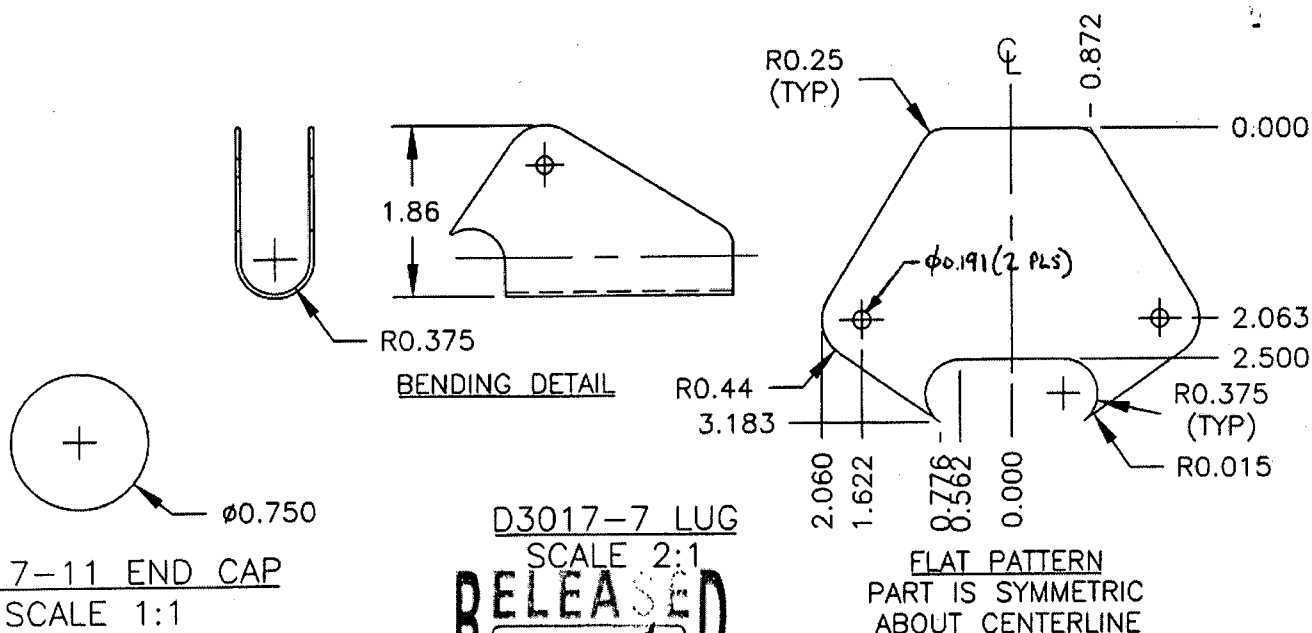
| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3017 | REV. A SHEET 1 OF 2 |
| DATE 01.05.18 | | TITLE BACK FRAME ASSEMBLY | SCALE 1:1 |
| A | 01.05.18 | NEW ISSUE | |

| QTY | PART No. | DESCRIPTION | MATERIAL |
|-----|-----------|---------------------|--|
| X | D3017-041 | BACK FRAME ASSEMBLY | N/A |
| 1 | D3017-1 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 2 | D3017-3 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 1 | D3017-5 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 3 | D3017-7 | LUG | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 2 | D3017-11 | END CAP | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36146*



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